



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D4292-1
Job Sheet 200378



Part No: D4292-1

Job Qty: 8 pcs

Part Name: Fitting



Part Weight: 0 lbs

Job Created: 9/10/19

Due Date: 10/15/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8		10/15/19	0.00	0.68	Bandsaw - 1		JL 19-10-07
		pcs							
110	HAAS 5 Axis - B4B	8		10/15/19	0.75	16.45	HAAS - 5 - B4B		JL 19-10-07
		pcs							
120	QC 2	8		10/15/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



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Container No: S220298



Part: D4292-1

Job No: 200378

Serial No/Batch: S220298

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/07/19

130 QC 8	8 pcs	10/15/19	0.00	0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	cm 19/10/09
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	10/15/19	0.00	0.45	Handfinish - 1 - 1 - B4B	BEB 19-10-10
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 -	

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
145	Powdercoat - 1 White GI(A)- B4B	8 pcs	10/15/19	0.00	0.59	Powdercoat - 1 - B4B Powdercoat - 2 - B4B Powdercoat - 3 - B4B Powdercoat - 4 - B4B
M193459 START: 1/40 OUT: 320° FWISA 2:10						BK A-10-11
150	QC 3	8 pcs	10/15/19	0.00	0.00	QC 3 - 10 QC 3 - 13 QC 3 - 15 QC 3 - 17 QC 3 - 18 QC 3 - 2 QC 3 - 28 QC 3 - 3 QC 3 - 30 QC 3 - 34 QC 3 - 36 QC 3 - 41 QC 3 - 51 QC 3 - 58 QC 3 - 59 QC 3 - 68 QC 3 - 9 QC 3 - 40 QC 3 - 19 QC 3 - 43 QC 3 - 24 QC 3 - 61 QC 3 - 81
						OCT 11 2010 68-6 07 DAS
151	Small Fab - 2 - B4B	8 pcs	10/15/19	0.00	0.36	Small Fab - 1 - B4B Small Fab - 2 - B4B Small Fab - 3 - B4B Small Fab - 4 - B4B Small Fab - 5 - B4B Small Fab - 6 - B4B Small Fab - 7 - B4B Small Fab - 8 - B4B
						DAS 58 OCT 11 2010 OCT 16 2010
152	QC 5	8 pcs	10/15/19	0.00	0.00	QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 43 QC 5 - 49

180 Packaging 3-1 - Stock - B4B

8

pcs

✓

10/15/19

0.00 0.00

Oscar NOV 11 2019

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

DAS

NOV 07 2019 40

9-89

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
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B4BPackaging 3 - 17 -
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B4BPackaging 3 - 19 -
B4BPackaging 3 - 20 -
B4BPackaging 3 - 21 -
B4BPackaging 3 - 22 -
B4BPackaging 3 - 23 -
B4BPackaging 3 - 24 -
B4BPackaging 3 - 25 -
B4BPackaging 3 - 26 -
B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4B

Packaging 3 - 32 -

ST547A

					B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	8 ✓ pcs	10/15/19	0.00	0.00	QC 21 - SA - 21 ✓	ST347A
					QC 21 - SA - 70	21
					QC 21 - SA - 53	53

NOV 11 2019

Part Op 100 - Bandsaw - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00*****
 Descriptions: 110 - HAAS CNC vertical machine #5 - 1-Machine per folio FB002
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 145 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - MASK THREADED HOLE
 150 - QC3- Inspect Part Finish
 151 - Small Fab - INSTAL HELICOIL
 152 - QC5- Inspect part completeness to step on W/O
 180 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	4.1600 ft (.52 ea)	100-Bandsaw - 1	S043 346
MS21209F1-10	Heli Coil	8 Ea (1 ea)	151-Small Fab - 2 - B4B	S120S16

4.3545
used

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B4.000x4.000	4	12	0
151-Small Fab - 2 - B4B	MS21209F1-10	8	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk	0625
2	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240		252
3	Fitting	0.125Inches + 0.030 - 0.010	0.155 0.115		126
4	Fitting	2.950Inches ± 0.030	2.980 2.920		2.946
5	Fitting	0.275Inches ± 0.010	0.285 0.265		274
6	Fitting	0.800Inches ± 0.010	0.810 0.790		799
7	Fitting	0.825Inches ± 0.010	0.835 0.815		825
8	Fitting	0.375Inches ± 0.010	0.385 0.365		375
9	Fitting	0.310Inches ± 0.030	0.340 0.280		312
10	Fitting	0.880Inches ± 0.030	0.910 0.850		873
11	Fitting	0.663Inches ± 0.010	0.673 0.653		663
12	Fitting	0.381Inches + 0.000 - 0.001	0.381 0.380		381
13	Fitting	1.125Inches ± 0.010	1.135		1.125

			1.115	
14	Fitting	1.063Inches ± 0.010	1.073 1.053	1.065
15	Fitting	3.440Inches ± 0.030	3.470 3.410	3.438
16	Fitting	2.450Inches ± 0.010	2.460 2.440	2.450
17	Fitting	1.325Inches ± 0.010	1.335 1.315	1.325
18	Fitting	0.300Inches ± 0.010	0.310 0.290	.300
19	Fitting	1.200Inches ± 0.010	1.210 1.190	1.200
20	Fitting	2.840Inches ± 0.030	2.870 2.810	2.837
21	Fitting	0.190Inches ± 0.030	0.220 0.160	.188
22	Fitting	5.860Inches ± 0.030	5.890 5.830	5.860
23	Fitting	5.990Inches ± 0.030	6.020 5.960	5.990
24	Fitting	0.272Inches + 0.006 - 0.001	0.278 0.271	.273
25	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265	.267
26	Fitting	1.750Inches ± 0.030	1.780 1.720	1.750
27	Fitting	0.250Inches ± 0.030	0.280 0.220	Radius .250
28	Fitting	0.060Inches ± 0.030	0.090 0.030	Radius .060
29	Fitting	4.875Inches ± 0.010	4.885 4.865	4.875
30	Fitting	0.493Inches ± 0.010	0.503 0.483	.491
31	Fitting	0.765Inches ± 0.010	0.775 0.755	c-bore .765
32	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	.255
33	Fitting	0.680Inches ± 0.010	0.690 0.670	.680
34	Fitting	2.250Inches ± 0.010	2.260 2.240	2.250
35	Fitting	4.500Inches ± 0.010	4.510 4.490	4.500
36	Fitting	1.275Inches ± 0.010	1.285 1.265	1.275
37	Fitting	0.031Inches ± 0.010	0.041 0.021	Radius .032
38	Fitting	0.130Inches ± 0.030	0.160 0.100	Radius .130
39	Fitting	1.650Inches ± 0.030	1.680 1.620	1.650
40	Fitting	1.421Inches ± 0.010	1.431 1.411	1.421

Plex 9/10/19 3:09 PM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____